

Date: Wednesday, 7/11/2007 2:48:52 PM  
User: Kim Johnston

Process Sheet

SP/it

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT FOR D206-642-512
Job Number	: 33485	Part Number	: K642 512
Estimate Number	: 12894	Drawing Number	: N/A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 7/11/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LANDING GEAR	Due Date	: 7/30/2007
Previous Run	: 33319	Qty:	1/2 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est Rev:A 05.06.07 new issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-512 CHG003

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D206648013 GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D206-648-013 GHW Kit B32401 ✓

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing B32467 ✓

5.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw B31927 (9) B33228 (11) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D29322

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

~~334~~

33489 ✓

50 ep

7.0

D29332

206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

~~B31251~~

33472 ✓

50 ep

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B32628 ✓

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B32469 ✓

10.0

D29382

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

B30282 ✓

11.0

D29392

206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

B30301 ✓

B30483 ✓

ep 7/14/07

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Job Number: 33485

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B32784 ✓

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B28926 ✓

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B33276 ✓

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B32909 ✓

16.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M18918 ✓

17.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M101261 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 33485

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M103324 (5x) -

18  
M105118 39

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M104936 -

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M104537 -

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M104537 -

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104936 -

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291 -

Ep 10/4/14 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 33485

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M18918 ✓

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918 ✓

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918 ✓

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M104885 ✓

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M104925 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 33485

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M103344-1

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M104679

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M104986

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M101418

33.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

M102536

34.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

M104812

EPH/42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 33485

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer

35.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H5

Washer

M104679

M104685

36.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H5L

Washer

M104679 (15x) - M104956 (1x)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-512 CHG003

Location:

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries